



Date: Thursday, 25/01/2007 8:35:30 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEB
Job Number : 30447	
Estimate Number : 10498	
P.O. Number : N/A	Part Number : D2739
This Issue : 25/01/2007 S.O. No. : N/A	Drawing Number : D2739 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : LANDING GEAR	Drawing Revision : C
Previous Run : 29997	Material : N/A
Written By : 	Due Date : 01/02/2007
Checked & Approved By : 	Qty: 4 Um: Each
Comment : Est Rev: C 02.11.28 Reformat KJ Est Rev: D 06-03-21 As Per Rev C JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D26005108	Extrusion 'I Beam' thin
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Extrusion 'I Beam' thin

Pick:

Qty Part Number Description Batch

1 D2600-5 Web

B 24410

DP, 5h 7-1-25 (4+1)
~~06-01-26 (5) P10~~

2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
-----	----------------	-------------------------

**Comment:** LANDING GEAR RESOURCE 1

1-Cut D2600-5 to length as per Dwg D2739.

2-Drill pilot holes in web using drilling Jig DT8162 as per Dwg D2739

3-Use uni-bit to open holes to finish size as per Dwg D2739.

4-Bevel Fwd ends (1" max) of extrusion and Deburr holes and ends.

5-Dburr

DP/5h 7-1-25 (P10)

3.0	QC5	INSPECT WORK TO CURRENT STEP
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**Comment:** INSPECT WORK TO CURRENT STEP

DP 7-1-25

P10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DP Date: 07/02/06
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-01-25	2.0	1 hole @ the FWD locat. in between the saddle holes (the 1" Ø) was drilled bad/very uneven & not round, caused by the uni-bit. Hole is oversized by .005" when corrected with a deburring tool.	<u>JS</u> <u>DP</u> <u>05/04/02</u>	Web unacceptable. Scraps destroyed, replace.	<u>JS</u> <u>DP</u> <u>7-1-25</u>	<u>JS</u> <u>DP</u> <u>07/02/06</u>	<u>JS</u> <u>DP</u> <u>05/04/02</u>	<u>JS</u> <u>DP</u> <u>07-01-25</u>
7-1-25	2.	① Wake out of Tolerance By .100, short. At the Fwd side. Human error.	<u>JS</u> <u>DP</u> <u>05/04/02</u>	Acceptable. Ensure employee verifies measurement before cutting.	<u>JS</u> <u>DP</u> <u>7-1-25</u>	<u>JS</u> <u>DP</u> <u>07/02/06</u>	<u>JS</u> <u>DP</u> <u>05/04/02</u>	<u>JS</u> <u>DP</u> <u>07-01-25</u>

NOTE: Date & initial all entries

Date: Thursday, 25/01/2007 8:35:30 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEB

Job Number: 30447

Part Number: D2739

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

BE 156 7-1-25

(4)

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

fm 07-01-26

(4)

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Use a red or black lead-free paint pen to write the part number and batch number in the middle of each web.

Identify and Stock

Location:

LG fm 07-01-26

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

207/02/06

Job Completion



U 207/02/06

RELEASED
DEC 20 1971

[illegible]

1) MATERIAL: MAKE FROM D2600-5 EXTRUSION
2) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
3) ALL DIMENSIONS ARE IN INCHES
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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